

Date: Wednesday, 4/4/2007 8:57:29 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : R44 BEARPAW |
| Job Number | : 31589A | | |
| Estimate Number | : 12480 | | |
| P.O. Number | : N/A | Part Number | : D35291 |
| This Issue | : 4/4/2007 S.O. No. : N/A | Drawing Number | : D3529 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A | Drawing Revision | : A |
| Previous Run | : 30634 | Material | : N/A |
| Written By | : | Due Date | : 4/20/2007 |
| Checked & Approved By | : <u>07.04.04</u> | Qty: | 17 |
| Comment | : Est Rev: A New Issue 06-06-28 JLM | Um: | 20 |
| | | Each | 0 |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|----------|---------------|
| 1.0 | MUHMWB10 | UHMW 1" Black |
|-----|----------|---------------|



Comment: Qty.: 1.2796 sf(s)/Unit Total: 25.5927 sf(s)
 Pick:
 blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)
 Material: Black UHMW 1"(MUHMWB10)
 Batch: M103975

SD 07/04/05 34

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

SD 07/04/05 34

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.07.07 34

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

MB 07/04/10 34

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

PPP 3 31588 07/4/12 34

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Yes Date: 07/04/16
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:57:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 31589A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



34

Comment: FINAL INSPECTION/W/O RELEASE

107104/16

Job Completion



U 2201-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

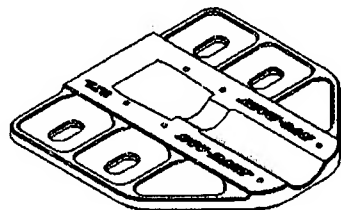
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

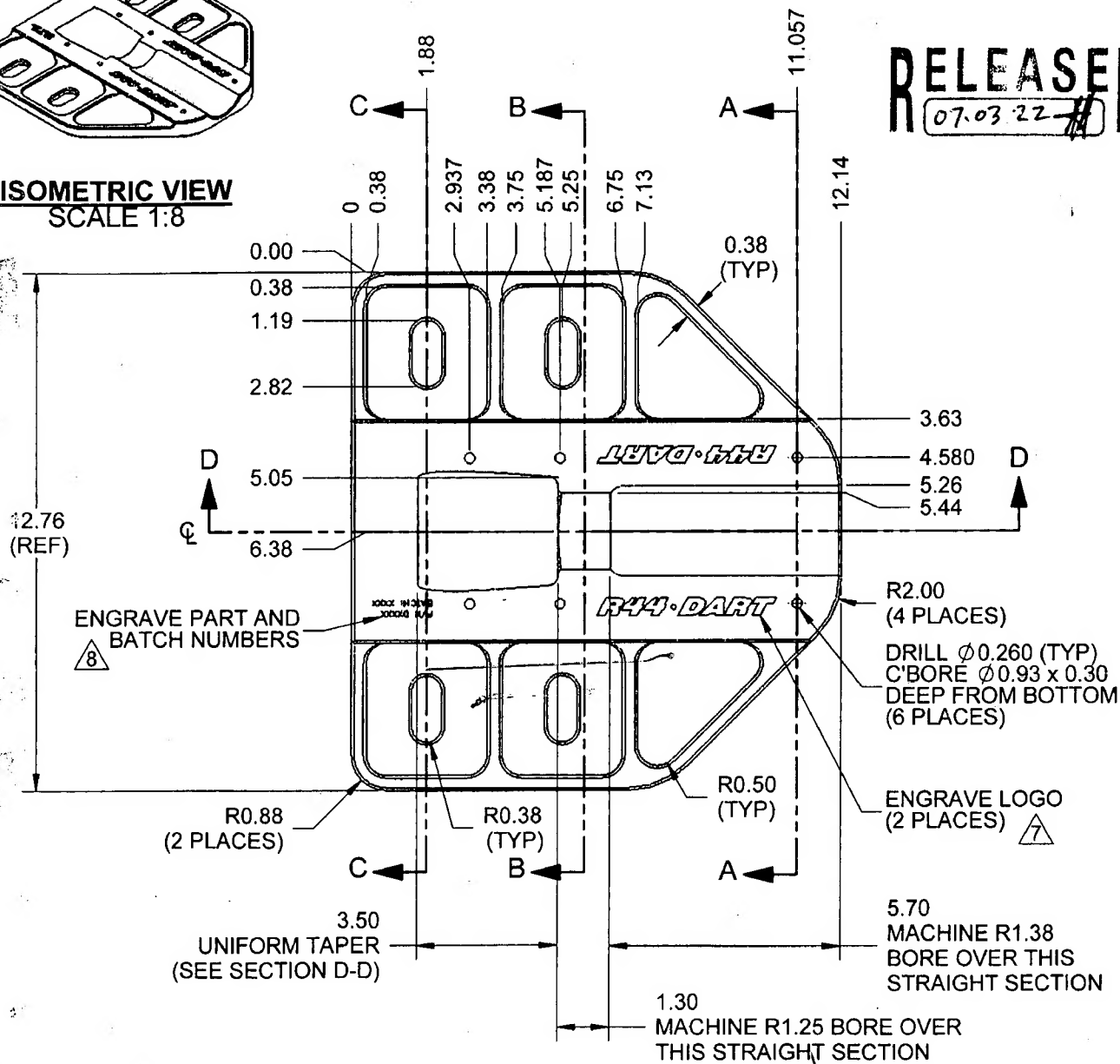


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN CB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3529 | REV. A SHEET 1 OF 2 |
| DATE 07.01.04 | | TITLE R44 BEARPAW | SCALE 1:4 |
| REV A | DATE 07.01.04 | DESCRIPTION NEW ISSUE | |



ISOMETRIC VIEW
SCALE 1:8

RELEASED
07.03.22



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31589A

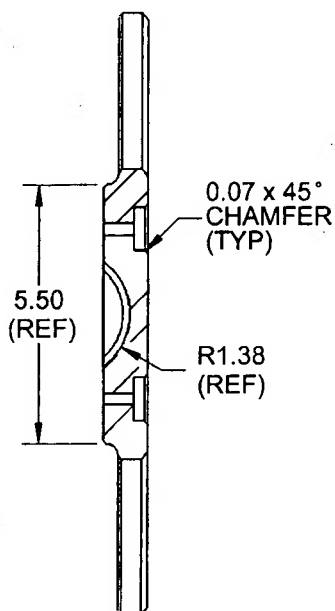
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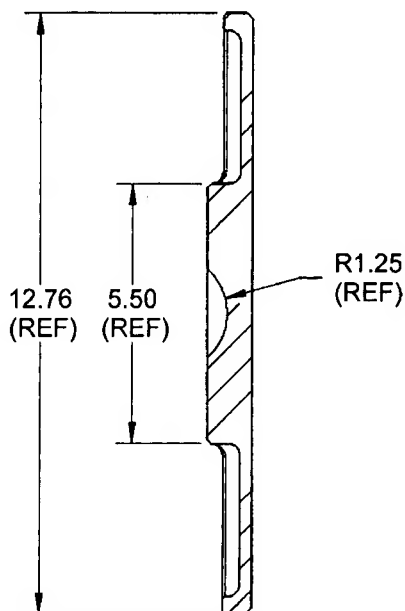


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN CB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3529 | REV. A SHEET 2 OF 2 |
| DATE 07.01.04 | | TITLE R44 BEARPAW | SCALE 1:4 |

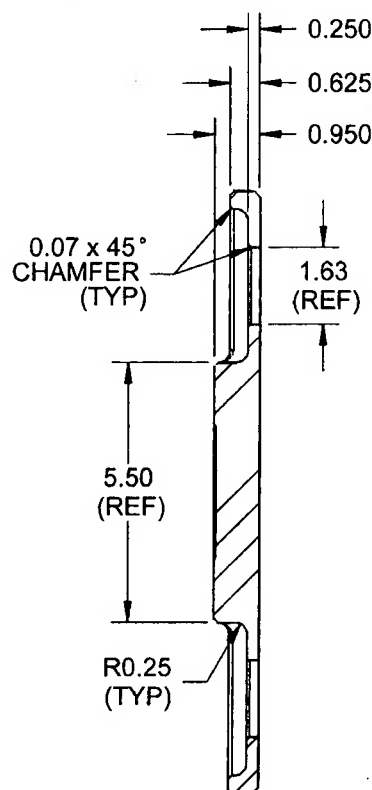
RELEASED
07.03.22



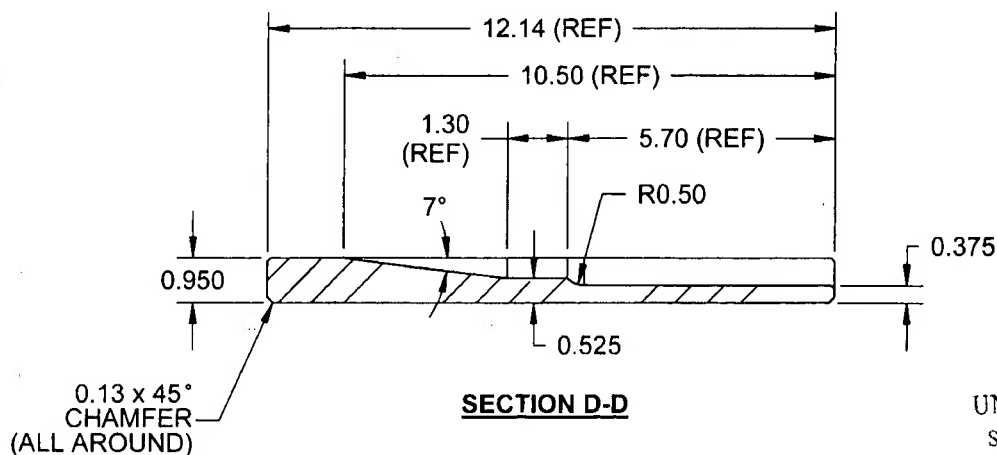
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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| | |
|-------------------------------------|-----------------------------|
| DART AEROSPACE LTD | Work Order: 31589A |
| Description: Bearpaw | Part Number: 03529-1 |
| Inspection Dwg: 03529 Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|----------------|---------------------|--------|--------|-------------------------|----------|
| A 5.50 | ±.030 | 5.503 | — | | | |
| B 0.07X45° | ±.030 | 0.051X45° | — | | | |
| C R0.25 | ±.030 | R0.250 | — | | | |
| D 0.250 | ±.010 | 0.242 | — | | | |
| E 0.625 | ±.010 | 0.617 | — | | | |
| F 0.950 | ±.010 | 0.951 | — | | | |
| G 1.63 | ±.030 | 1.620 | — | | | |
| H 12.14 | ±.030 | 12.140 | — | | | |
| I 10.50 | ±.030 | 10.530 | — | | | |
| J 5.70 | ±.030 | 5.730 | — | | | |
| K 0.375 | ±.010 | 0.373 | — | | | |
| L 0.525 | ±.010 | 0.523 | — | | | |
| M 0.13X45° | ±.030 | 0.121X45° | — | | | |
| N R0.500 | ±.030 | R0.500 | — | | | |
| O 12.76 | ±.030 | 12.760 | — | | | |
| P 2.937 | ±.010 | 2.939 | — | | | |
| Q 5.187 | ±.010 | 5.191 | — | | | |
| R 0.38 | ±.030 | 0.380 | — | | | |
| S 11.057 | ±.010 | 11.060 | — | | | |
| T Ø0.260 | ±.006 ±.001 | Ø0.260 | — | | | |
| U 0.30 | ±.030 | 0.309 | — | | | |
| V Ø0.93 | ±.030 | Ø0.928 | — | | | |
| W 1.30 | ±.030 | 1.281 | — | | | |
| X | | | | | | |
| Y | | | | | | |

| | | | |
|--------------------------------|-------------------------------|----------------------------|-----|
| Measured by: <i>QML</i> | Audited by: <i>J.L</i> | Prototype Approval: | N/A |
| Date: 07/04/05 | Date: 07/04/05 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.01.09 | New Issue | KJ/RF | |